

**Patent claims**

1. A heat exchanger unit, in particular for a motor vehicle, comprising at least one heat exchanger, having  
5 tubes and heat-transfer fins, and having at least one side part, which comprises a baseplate and at least one reinforcing fin, characterized in that at least one reinforcing fin is formed by a deformed center piece of the surface of the baseplate.
- 10 2. The heat exchanger unit as claimed in claim 1, characterized in that at least one reinforcing fin runs in a longitudinal direction of the side part.
- 15 3. The heat exchanger unit as claimed in claim 1 or 2, characterized in that at least one reinforcing fin runs in a transverse direction of the side part.
- 20 4. The heat exchanger unit as claimed in one of claims 1 to 3, characterized in that at least one reinforcing fin runs at an angle  $\alpha$ , where  $0^\circ < \alpha < 90^\circ$ , with respect to a longitudinal direction of the side part.
- 25 5. The heat exchanger unit as claimed in one of claims 1 to 4, characterized in that at least one reinforcing fin is provided with at least one securing means.
- 30 6. The heat exchanger unit as claimed in claim 5, characterized in that the at least one securing means is formed by an at least partially deformed reinforcing fin.
- 35 7. The heat exchanger unit as claimed in one of claims 1 to 6, characterized in that the side part has at least one expansion section, which is formed by one or more apertures, in particular aligned with one another, and a plurality of webs adjoining the

apertures, at least one aperture corresponding to a center piece of the surface of the baseplate which has been deformed to form a reinforcing fin.

- 5 8. The heat exchanger unit as claimed in claim 7, characterized in that the webs have fold-like beads.

9. A process for producing a side part for a heat exchanger unit comprising at least one heat exchanger,  
10 characterized by the process steps of a) providing an areal metal sheet having a width b which is substantially equal to a width of the side part, b) precutting sections of an edge of at least one piece of the surface of the metal sheet, and c) deforming the at  
15 least one piece of the surface out of a plane which is predetermined by the areal metal sheet, to form at least one reinforcing fin.